

Date: Tuesday, 04/11/2008 11:19:33 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 43194	
Estimate Number : 13374	
P.O. Number :	Part Number : D37695
This Issue : 04/11/2008 S.O. No. :	Drawing Number : D3769 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 41385	Material :
Written By :	Due Date : 20/11/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JLD 08.11.04</u>	
Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC Est Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
Comment: Qty.: 1.7579 f(s)/Unit Total : 21.0949 f(s) (10,5474) M-1 09/01/07 (12x) 6061T6 TUBE (1.00" x 0.65" wall) M109760 (6x) / M109116 (6x) batch: _____		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 (10,5474)
Comment: SMALL & MEDIUM FAB RESOURCE 1 (12x) 1-cut tube to length as per dwg D3769 2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig 3- deburr M-1 09/01/07		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP S 02/04/08 (12)		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 (12) Chemical Conversion Coat as per QSI 005 4.1 F2 09/01/12		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 09-01-12 (12)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: TUBE

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST250

SS 09/01/12 (RD)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/13

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

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C

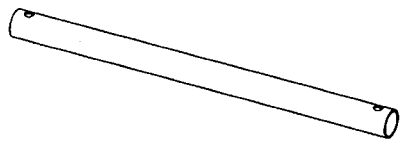
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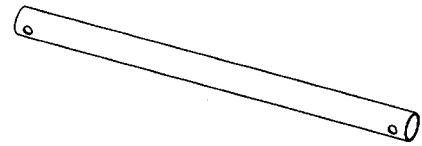
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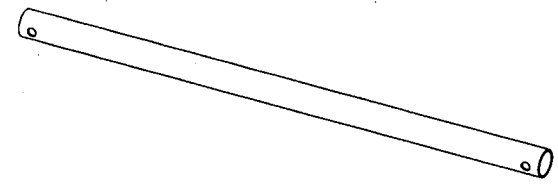
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D3769-1 TUBE



D3769-3 TUBE







D3769-5 TUBE

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08-06-11

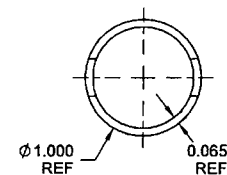
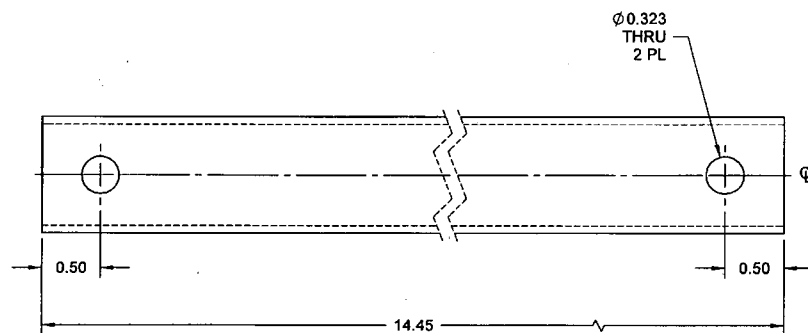
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NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

A		NEW ISSUE		HS	08.06.04
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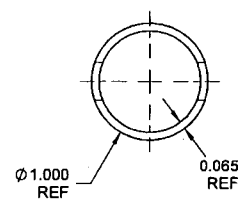
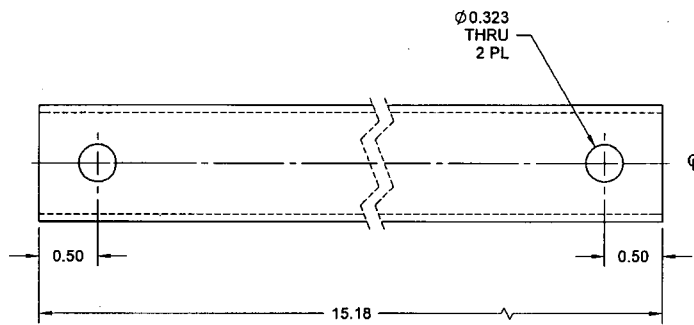


D3769-1 TUBE

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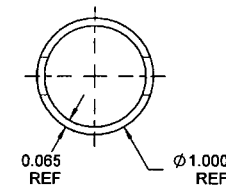
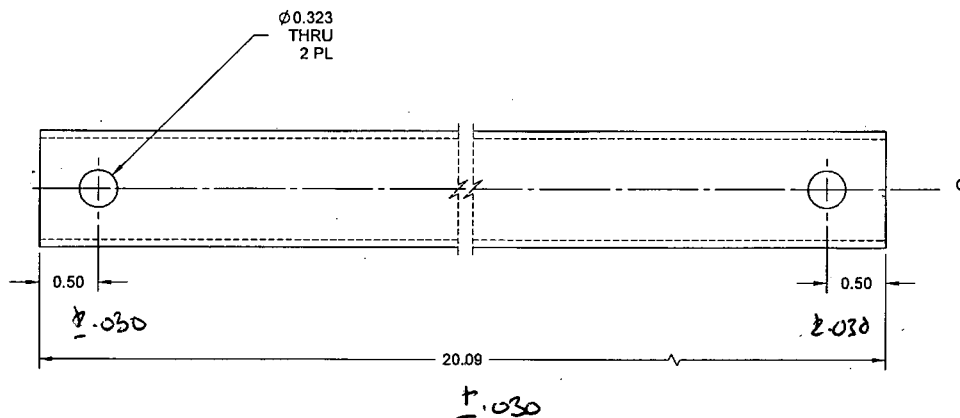


D3769-3 TUBE

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D3769-5 TUBE

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